

Work Order ID 50813

July 22, 2009 3:02:29 PM



Page 1

Item ID: D2224
Revision ID: E
Item Name: Rappel Anchor

Accept



Setup Start



Stop



Start Date: 7/24/09 Start Qty: 10.00
Required Date: 7/28/09 Req'd Qty: 10.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan:
QC:

[Handwritten signature]

Date:
Date:

Tooling:
SPC (Y/N):

Date:
Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2224

Rev E

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jcaspa Bandsaw

Cut blanks: 2.8" *****Note grain direction *****

mk 09/07/23

17

0

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per Folio D2224 & Dwg D2224: 2-Deburr & Tumble

mk 09/07/24

16

1

(PTO)



120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

mk 09/07/24

16

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2224 PAR #: N/A Fault Category: Mach. We NCR: Yes No DQA: / Date: 09.08.24
 QA: N/C Closed: / Date: 09.08.27

NCR: <u>50813</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>09/07/23</u>	<u>110</u>	<u>1 part scrap. I place the part in wrong direction. grain direction R.C. operator error.</u>	<u>/</u> <u>09/08/24</u>	<u>scrap and destroy no replace.</u>	<u>ml</u> <u>09/07/24</u>	<u>SA</u> <u>09/07/24</u>	<u>/</u> <u>09/08/24</u>	<u>/</u> <u>09.07.24</u>

NOTE: Date & initial all entries

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Accept



Setup Start



Stop



Start Date: 7/24/09 Start Qty: 10.00
Required Date: 7/28/09 Req'd Qty: 10.00



Cust Item ID:
Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

SA0510724

16

QC

Memo

0.00

Quality Control

140

Outsource process-Anodize per QSI017 4.1.10.1

0.00

Outsource4

Memo

0.00

Outsource process - Anodize

Issue P/O: 10180 Red Anodize as per Dwg D2224 MIL-A-8625

C2doveth (12 09108107 16
(TRM is closed until Aug 10th 16)

150

Receive & Inspect for Damage & Mat'l Certs

0.00

Packaging

Memo

0.00

Packaging

Pc 8/17 (16)

OK

Picklist Print

July 22, 2009 3:02:28 PM

Page 1

Work Order ID: 50813

Parent Item: D2224RevE

Parent Item Name: Rappel Anchor

Comments:

Start Date: 7/24/09

Required Date: 7/28/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M7075T73B2.500X03.2 5		Purchased	No			100	f	5.3300	2.3263			



7075-T73 Bar 2.50 x 3.25



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		

Main Warehouse

MAT	5.33
-----	------

102694	5.33
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M107955

NO MORE MATL

~~2.3263~~
3.966' ML 09/07/23

MA

DART AEROSPACE LTD		Work Order:	50813
Description: Rappel Anchor		Part Number:	D2224
Inspection Dwg: D2224 Rev: E		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.188	+/-0.010	.186	✓			
0.050 x 45°	+/-0.010 x 0.5°	.045 x 45°	✓			
0.250	+/-0.010	.248	✓			
R0.500	+/-0.010	R.500	✓			
3.000	+/-0.010	3.000	✓			
Ø0.507	+0.008/-0.001	Ø.509	✓			
0.750	+/-0.010	.750	✓			
2.313	+/-0.010	2.314	✓			
1.687	+/-0.010	1.687	✓			
2.438	+/-0.010	2.440	✓			
1.125	+/-0.010	1.125	✓			
Ø0.313	+0.006/-0.001	Ø.313	✓			

Measured by:	anl	Audited by:	SL	Prototype Approval:	N/A
Date:	09/07/24	Date:	09/01/24	Date:	N/A

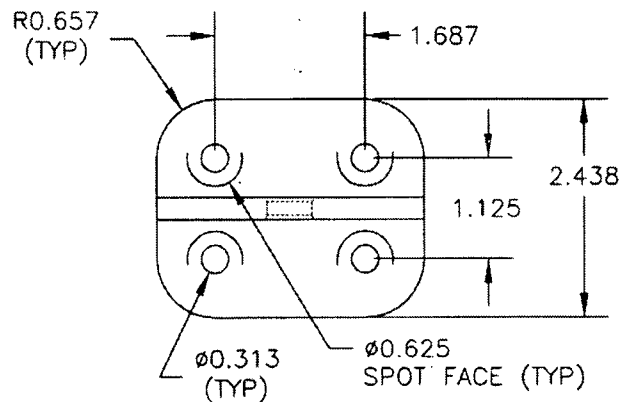
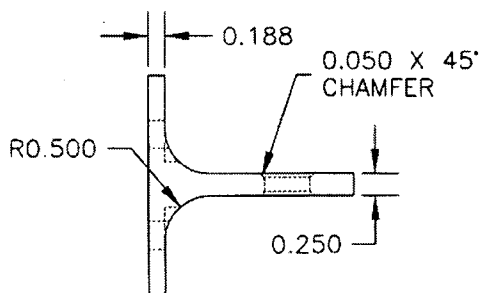
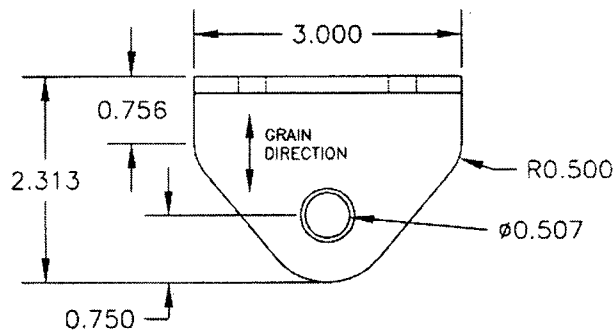
Rev	Date	Change	Revised by	Approved
A	08.04.11	New Issue	KJ/DD	AS



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2224	REV. E SHEET 1 OF 1
DATE 99.04.29		TITLE RAPPEL ANCHOR	SCALE 1:2
A	94.03.10	NEW ISSUE	
B	95.04.11	D2227 WAS D2216	
C	96.06.17	ADDED D2224-60	
D	97.04.25	CHANGE TO T-SHAPE	
E	99.04.29	REVISE MATERIAL SPECIFICATIONS	

RELEASED
94.04.11 KE

*w/o
5083*



MATERIAL: 7075-T7351 (QQ-A-200/11) OR 7075-T651 (QQ-A-200/11)
FINISH : ANODIZE RED PER MIL-A-8625
BREAK ALL UNMARKED EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



TNM**ANODISATION et PEINTURE TNM INC.**

C. OF C

21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 certified

approuvé NADCAP approved

76659

8/14/2009

CLIENT / CUSTOMER:**DART AEROSPACE LTD.**

1270 ABERDEEN STREET

HAWKESBURY , ONTARIO

K6A 1K7

**CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE****NO. DE COMMANDE: 513966
PURCHASE ORDER/**

ITEM	COMMANDE ORDERED	EXPEDIE SHIPRED	PART NUMBER & DESCRIPTION		PART PROCESS & TREATMENT
1	16	16	D2224	B50813	RED ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER
2	6	6	D2224	B50515	RED ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER
3	30	30	D2224	B50878	RED ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER

S 02/08/18

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.

Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.

Travel cards have been filled and are available for viewing upon request.

NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient Temperatures"

NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air ambiant.

Signature/Signed:

Directeur de la Qualité / Q.A. Manager

Part Aerospace
1270 Aberdeen St.
Hawkesbury ont.
K6A-1K7

N° DE COMMANDE - ORDER NO.		DÉP. - DEPT.	DATE 09/08/07
VENDU À - SOLD TO		EXPÉDIÉ À - SHIP TO Anodizing+Paint 21 Aviation RD	
ADRESSE - ADDRESS		ADRESSE - ADDRESS Yamte-Clair QC. H9R-4Z2	

DATE D'EXPÉDITION - SHIPPING DATE	VIA P/O: 10180	CONDITIONS - TERMS	N° D'ENR. DE TAXE - TAX REG. NO.	VENDEUR - SALESPERSON 514-429-7777
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16	D2224	B 50813	S 6/08/18	
6	D2224	B 50515		
30	D2224	B 50878		
Red anodize as per				
MIL-A-8625F type 1 or				
1B 11/1C 11B class 2				
please ship back:				
pilot's acct # 7684382				
thanks				
Chantal				
CERTIFICATE OF CONFORMITY REQ'D UPON DELIVERY				
TPS/GST				
TVP/PST				

513966

SIGNATURE

N° LIC. - LIC. NO.

TOTAL